

Date: Tuesday, 4/25/2006 7:35:12 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 350 SKIDTUBE EXTRUSION (BENT)
Job Number	: 26787		
Estimate Number	: 10997		
P.O. Number	: N/A	Part Number	: D26003BENT
This Issue	: 4/25/2006 S.O. No. : N/A	Drawing Number	: D2600 REV D1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: D1
Previous Run	: 25384	Material	: N/A
Written By	: <u>SKJ COMMENT BELOW</u>	Due Date	: 5/5/2006
Checked & Approved By	: <u>06.04.25</u>	Qty:	<u>30</u> Um: Each
Comment	: Est. B02 11.28 Reformat KJ		<u>49</u>

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D26003120	Extrusion Round 3" 350
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 30.0000 Each(s)

Extrusion Bent

Pick:

Qty	Part Number	Description	Batch
1	D2600-3	Extrusion	B23201

DP/ 05-6-31

49

2.0	BENDING	BENDING MACHINE
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Comment: BENDING MACHINE

Deburr one end of extrusion

Drill #30 pilot holes using DT8689

Open holes to 5/16" and deburr

Bend using CNC bending machine as per program 2750.C and Folio FT003.

Use 5/16 locator pin on buggy "A".

Check fit to Jig DT8150

DP/ 05-6-31

DP 05-6-31

49

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

Inspect work to Step 6 Ensure fit to Jig DT8150

BE 05-6-31

49

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 46

DP 05-6-31

49

PTO

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2600-3B PAR #: NA Fault Category: Prod/Landing Gear NCR: (Yes) No DQA: DP Date: 06/06/01
 QA: N/C Closed: HY Date: 06.06.01

NCR: <u>26787</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>06-5-31</u>	<u>2.</u>	<u>Tube over heat</u>	<u>DP</u> <u>over</u>	<u>Tube over heat</u> <u>Scrap & destroy</u> <u>+ Replace.</u>	<u>DP</u> <u>06-5-31</u>	<u>BE</u> <u>06-5-31</u>	<u>DP</u> <u>over</u>	<u>DP</u> <u>06-5-31</u>

NOTE: Date & initial all entries

Date: Tuesday, 4/25/2006 7:35:13 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE EXTRUSION (BENT)

Job Number: 26787

Part Number: D26003BENT

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06/06/01 (59)

Job Completion



06/06/01

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2600	REV. D SHEET 1 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1
A	97.01.21	NEW ISSUE	
B	97.09.09	CHANGE MATERIAL SPEC.	
C	98.04.16	ADD D2600-3, UPDATE D2600-1 WIDTH, ADD DIE NO.	
D	98.08.20	INCREASE MIN. UTS TO 40 KSI	
DI	01.04.17	ADD PART NUMBERS & DIE NUMBERS <i>+GP</i>	

RELEASED
18.08.25 DS

GENERAL NOTES

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi
MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES.

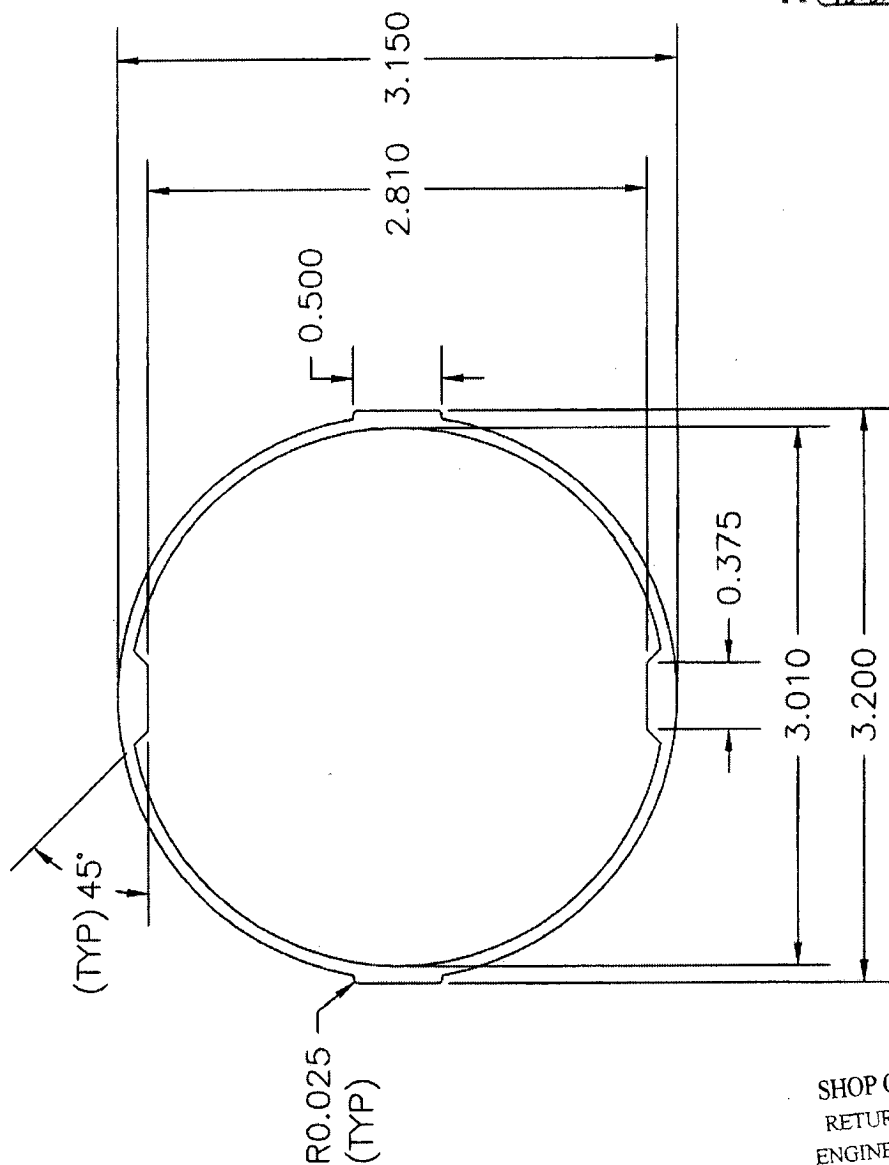
2. BREAK ALL SHARP CORNERS 0.010 MAX.
3. NO TOOLING MARKS.
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
5. ALL DIMENSIONS ARE IN INCHES.

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WORK ORDER
NO. 26787



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CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2600	REV. D SHEET 2 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

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98.8.25 DS



D2600-1

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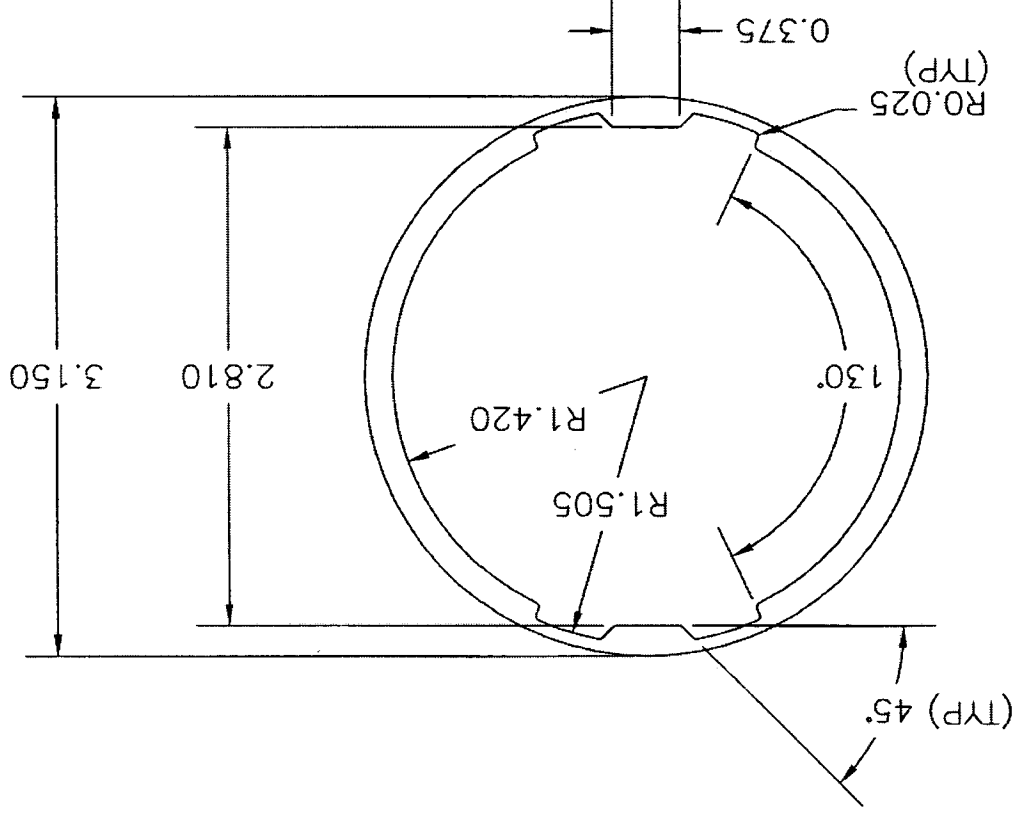
MANUFACTURED WITH CARADON INDALEX DIE # MH-18870
OR BON L DIE # 897121 (PREFERRED CHOICE)
PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-1-160 IS 16.0" LONG)





DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. D
KE	[Signature]	D2600	SHEET 3 OF 5
DATE	TITLE		SCALE
98.08.20	EXTRUSION		1:1

RELEASED
98.8.25 DS



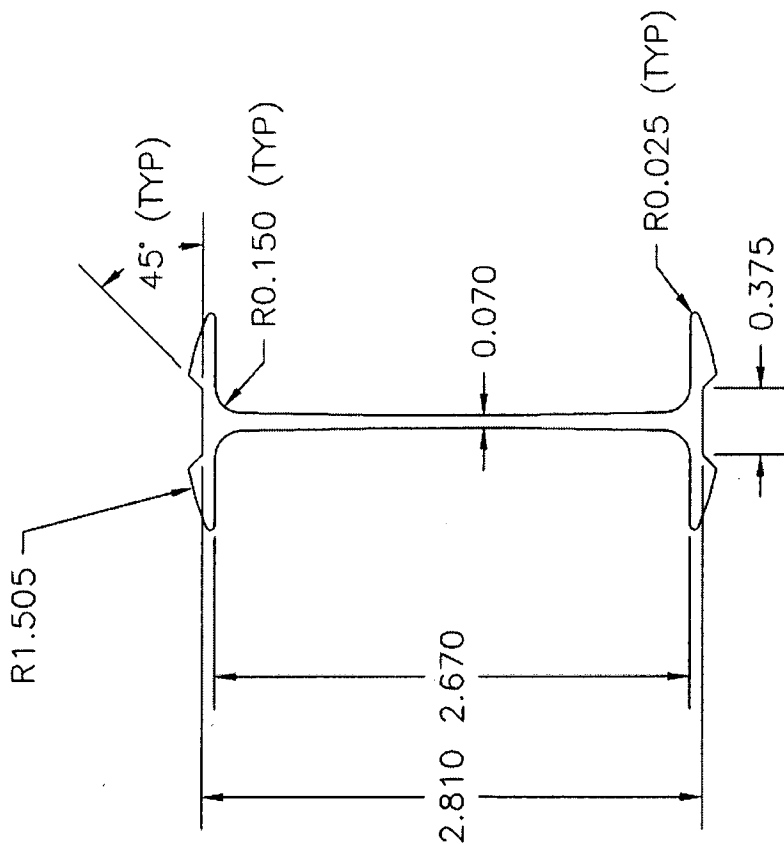
D2600-3
MANUFACTURED WITH CARADON INDALEX DIE # MH-18859
OR BOWL DIE # 891122 (PREFERRED CHOICE)
PART NUMBER IS D2600-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-3-120 IS 120 LONG)

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CHECKED <i>KE</i>	APPROVED <i>MA</i>	DRAWING NO. D2600	REV. D SHEET 4 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED
98.8.25. DS



D2600-5

MANUFACTURED WITH CARADON INDALEX DIE # MS-18871
PART NUMBER IS D2600-5-XXX WHERE XXX IS CUT LENGTH IN INCHES
(EG. D2600-5-108 IS 108" LONG)

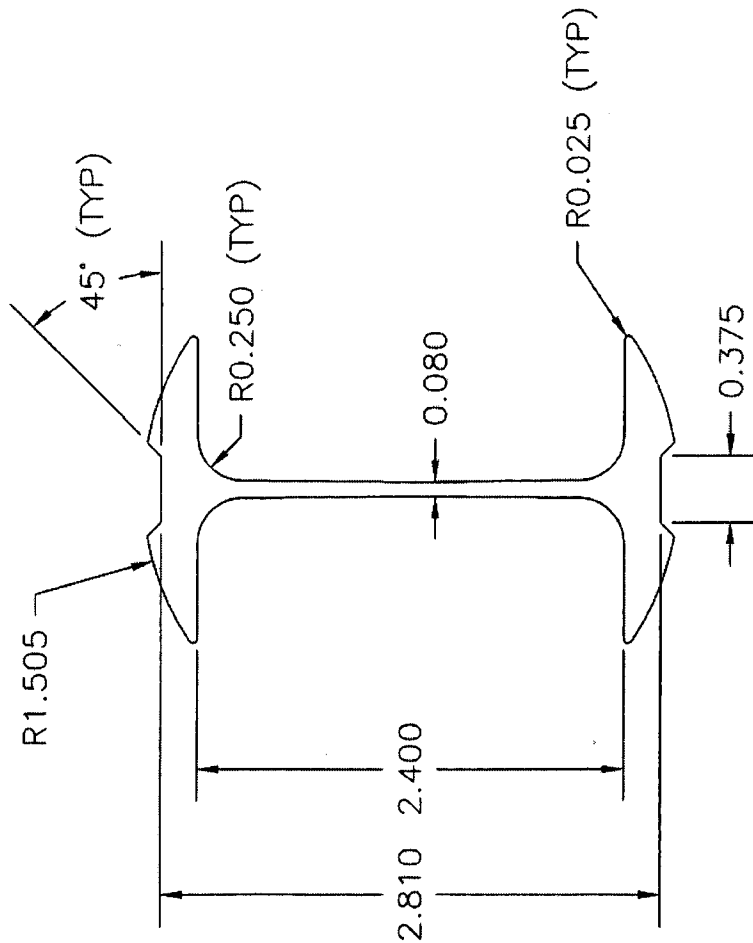
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DESIGN <i>RA</i>	DRAWN BY <i>RA</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>AS</i>	DRAWING NO. D2600	REV. D SHEET 5 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED
98.8.25 DS



D2600-7

MANUFACTURED WITH CARADON INDALEX DIE # MS-18872
PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH IN INCHES
(EG. D2600-7-125 IS 125" LONG)

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